

**Work Order ID 68741**

Page 1

Thursday, April 21, 2011 8:16:33 AM

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3492	C								
D4168	A								
IIN-D350-636	H								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-016 CHG 002

B69720

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr, section R-R

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R

5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168 Detail J

6- Drill pilot holes as per Dwg D4168 sheet 5 (D4168-2 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail K.  
\*\*\*SECOND SIDE\*\*\*

8- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole

9- Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201 iplace per side and open holes of detail M section R-R to 0.500" as per dwg D4168

10- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: ☐

M116577 BE 11/04/28

BB 11/04/26

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

11-Grind welds flush as per Dwg D4168

BB 11/04/29

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8 u104/29

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 u104/29

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

⇒ m.d

11/05/02

(IX)

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1 d all 11/05/02

W/O:		WORK ORDER CHANGES					
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Reference:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D4168.2-Open up holes of Detail K to 0.750" (total of 4 holes per side)  
as per dwg D4168.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168  
(welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: 11/6918 ☐☐☐  
exp. date: 12/1/158- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004  
(welding instructions on sheet 8)A/R ☐☐☐ Aluminum Rod batch: m11/6577

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D4168

AS 11/05/05

11/05/05

11/05/05

BE 11/05/06

BB 11/05/09

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Spot face ground handling holes section (total of 4 places per side) as per .  
dwg D4168

12- C'bore section CH-CH

13- Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 0 24 4/25/11

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:25  
OVEN TEMPERATURE: 320°  
FINISH TIME: 3:55

1 0 24 4-5-11

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 0 24 4/6/11

W/O:		WORK ORDER CHANGES					
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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

✓ 1- Install inserts as per Dwg D4168

1 0 24 11/06/13

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168

✓ SIKA FLEX 241  
BATCH: 11116945  
EXP DATE: 12/01✓ 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube  
A/R 55-o-ring lube batch: 11114189✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: 11115941 0 24 11/06/13

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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

If making a D350-636-216□  
pick kit will only requires:  
1 X AN3C37A  
1 X AN3C34A  
1 X AN3C42A  
2 X D3493-1

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270  Packaging	Packaging	0.00							
Packaging	<b>Memo</b> Identify and pack for shipping as per PPPD350-636-016 Location: _____ PPP rev: _____	0.00							
280  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	<b>Memo</b>	0.00							

PP 69720

11/6/15

11/6/15

ME  
11-06-15

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# Picklist Print

Thursday, April 21, 2011 8:16:40 AM

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Work Order ID: 68741

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC  
11.04.14 ecn11-553 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3490-1		Manufactured	No			160	Each	93.0000	4	4			
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Cross Bolt Spacer

Location	Loc Qty	Loc Code
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LG	91	
----	----	--

67773	31	
-------	----	--

68105	60	
-------	----	--

LG001	2	
-------	---	--

62450	2	
-------	---	--

D3490-3		Manufactured	No			160	Each	66.0000	4	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Cross Bolt Spacer

Location	Loc Qty	Loc Code
----------	---------	----------

LG	26	
----	----	--

68106	26	
-------	----	--

LG001	40	
-------	----	--

67774	40	
-------	----	--

AN3C34A		Purchased	No			230	Each	13.0000	1	1			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--



BOLT

Location	Loc Qty	Loc Code
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ST353	13	
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116003	13	
--------	----	--

BE 4/25/06

4

BE 4/25/06

4

11/6/138

1

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Purchased

No

230

Each

181.0000

4

4



BOLT



4/20/11

Location

Loc Qty

Loc Code

FG

14

101261

4

116590

10

FP-B

47

111925

47

ST303

20

116590

20

ST353

100

117125

100

AN3C37A

Purchased

No

230

Each

129.0000

1

1



BOLT



4/20/11

Location

Loc Qty

Loc Code

ST353

29

116874

11

117010

18

ST354

100

117343

100

AN3C42A

Purchased

No

230

Each

52.0000

1

1



BOLT



4/20/11

Location

Loc Qty

Loc Code

ST354

52

106176

52

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 3

Thursday, April 21, 2011 8:16:41 AM

Work Order ID: 68741

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

12.0000

1

1



Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

12

62003

4

65099

8

D3492-1

Manufactured No

230

Each

0.0000

8

8



Plug

D3492-3

Manufactured No

230

Each

0.0000

8

8



D3492-043

Plug

D3873-1

Manufactured No

230

Each

123.0000

7

7



Bushing

Location

Loc Qty

Loc Code

ST088

123

62197

12

63314

2

64567

9

64760

100

D4154-041

Manufactured No

230

Each

0.0000

1

1



Wearplate Assembly

368361



(x1) All uloc 13

Thursday, April 21, 2011 8:16:41 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:16:41 AM

Page 4

Work Order ID: 68741

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4170-1

Manufactured No

230

Each

50.0000

4

4



Bushing



BE11/05/06

Location

Loc Qty

Loc Code

LG

46

61581

5

68225

41

LG002

4

65912

4

D4171-1

Manufactured No

230

Each

8.0000

1

1



Bushing



HL 1106113

Location

Loc Qty

Loc Code

ST135

8

65646

8

B 69037

MS21043-3

Purchased No

230

Each

930.0000

5



Nut



XL  
HL 1106113

Location

Loc Qty

Loc Code

FG

80

103691

80

FP-B

-5

112314

-5

ST301

855

112314

855

XL

Thursday, April 21, 2011 8:16:41 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:16:41 AM

Work Order ID: 68741



Parent Item: D350-636-016



Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0363R

Purchased

No

230

Each

4,735.000

9



Washer



97

HL 1106113

Location

Loc Qty

Loc Code

ST297

4735

113889

81

114742

4654

NAS1515H3L

Purchased

No

230

Each

285.0000

4



WASHER



X7

4

HL 1106113

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

245

113362

245

NAS1611-010

Purchased

No

230

Each

266.0000

8



O-RING



X8

8

HL 1106113

Location

Loc Qty

Loc Code

FP

80

117460

80

FP-A

186

110915

139

115589

47

X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:16:42 AM

Work Order ID: 68741

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

176.0000

8

8



O-RING



*Handwritten: 11/06/13*

Location

Loc Qty

Loc Code

FP

171

117291

131

117460

40

FP-A

5

116582

5

*x2*

AN960JD816

Purchased

No

250

Each

45.0000

2

2



1/2" washer, Alum



*Handwritten: 11/06/13*

Location

Loc Qty

Loc Code

FP-A

45

106043

45

*x2*

D2744

Manufactured

No

110

Each

37.0000

1

1



Cap



*Handwritten: 11/04/28*

Location

Loc Qty

Loc Code

LG002

37

62715

8

65086

29

*/*

D2600-3-BENT

Manufactured

No

110

Each

29.0000

1

1



Extrusion Bent



Location

Loc Qty

Loc Code

LG

29

66874

1

66875

8

68137

10

68138

10

*+*

*Handwritten: 11/04/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, April 21, 2011 8:16:42 AM

Work Order ID: 68741

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160 Each

123.0000 8 8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

123

67766

123

D2739

Manufactured No

160 Each

14.0000 1 1



350 I Beam

Location

Loc Qty

Loc Code

LG

14

67785

2

68285

6

68286

6

ALS4-1032-225

Purchased No

230 Each

1,113.000 4 4



Insert

Location

Loc Qty

Loc Code

FP-B

40

110768

40

ST282

1073

110768

1073

AN8C35A

Purchased No

230 Each

30.0000 1 1



BOLT

Location

Loc Qty

Loc Code

FP-A

30

115960

7

116874

23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:16:42 AM

Work Order ID: 68741

Parent Item: D350-636-016


Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011


Required Date: 4/25/2011

Start Qty: 1.00


Required Qty: 1.00

AN6C44A Purchased No 230 Each 86.0000 4 4  
  
 BOLT HL 1106113


Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST344	84	<u>vd</u>
116874	4	
117407	80	

MS21083C8 Purchased No 230 Each 91.0000 1 1  
  
 NUT HL 1106113

Location	Loc Qty	Loc Code
FP-B	1	
115884	1	
ST303	90	
115884	0	
117291	40	<u>xl</u>
117423	50	

D3631-1 Manufactured No 230 Each 500.0000 8 8  
  
 Washer HL 1106113

Location	Loc Qty	Loc Code
ST072	500	
68062	500	<u>xb</u>

AN960C10L NAS1149C0332 Purchased No 230 Each 0.0000 4 4  
  
 washer M117291 (xd) HL 1106113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:16:43 AM

Page 9

Work Order ID: 68741

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No

230 Each

13.0000 8 8



Bushing



22 1106113

Location

Loc Qty

Loc Code

FP-A

13

1368248

X2

67764

13

AN960C816L

Purchased No

230 Each

0.0000 1 1



NAS 1149C0832R



1114915 (X1) 22 1106113

WASHER

AN3C6A

Purchased No

230 Each

224.0000 4 4



22 1106113

BOLT

Location

Loc Qty

Loc Code

FP-A

1

M117514

X4

111982

1

ST351

223

111982

2

116419

71

116549

50

116704

100

MS21043-6

Purchased No

230 Each

527.0000 4 4



22 1106113

NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

44

112314

44

X4

ST301

463

112314

463

Thursday, April 21, 2011 8:16:43 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:16:43 AM

Work Order ID: 68741

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250 Each

33.0000

2



Washer

11/6/10

Location

Loc Qty

Loc Code

ST062

33

66975

33

2

MS21083C8

Purchased No

250 Each

91.0000

2



NUT

11/6/13

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

90

115884

0

117291

40

117423

50

x2

AN8C21A

Purchased No

250 Each

28.0000

2



BOLT

11/6/13

Location

Loc Qty

Loc Code

ST345

28

116381

28

x2

D2741

Manufactured No

250 Each

50.0000

1



Blade, 350 Skidtube

11/05/18

Location

Loc Qty

Loc Code

ST466

50

61341

12

63589

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

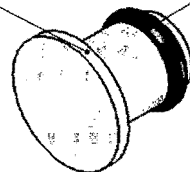
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68741

D3492-21

UNDER REVIEW  
02.04.2008

OK-ASS 08.11.12

DEO ATTACHED

RELEASED  
01.01.16

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>[Signature]</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>[Signature]</u>		
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>[Signature]</u>	D3492	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	PLUG	2:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

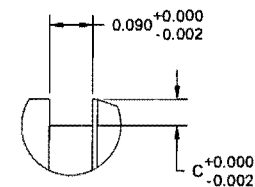
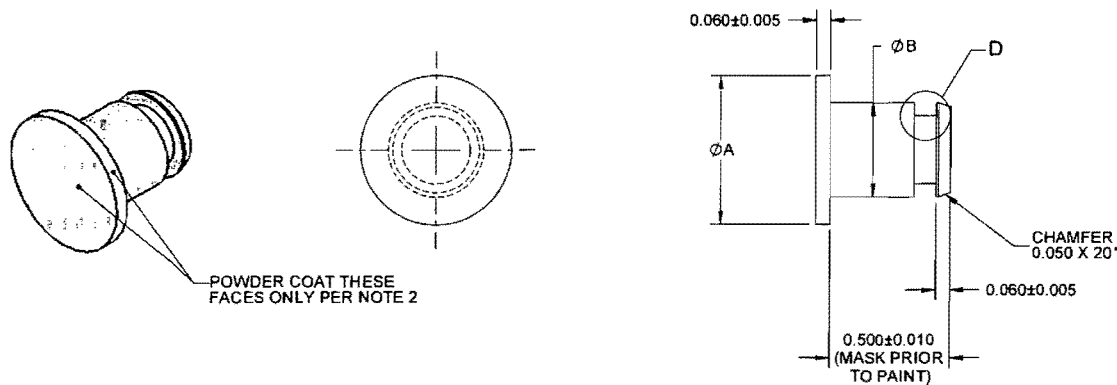
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**DETAIL D**

**D3492-XX PLUG**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3 5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

*WLO 68741*

**UNDER REVIEW**

*03.04.11 PBA*  
*05M 0.0 0.1 D3492-13*  
*REF. 0.2 (HOLE SHIMMER)*  
*ASS 08.11.12*  
*OKay*

**DEO ATTACHED**

**RELEASED**  
*07.11.16*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3492</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>PLUG</b>	4:1
DATE	<b>07.10.05</b>	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR. <i>B</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>			
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05	DATE 08/11/05			

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

*W/O 48741*

WAS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**RELEASED**  
08/11/10 *MP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1	1	1	D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

u/o 68741

# GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

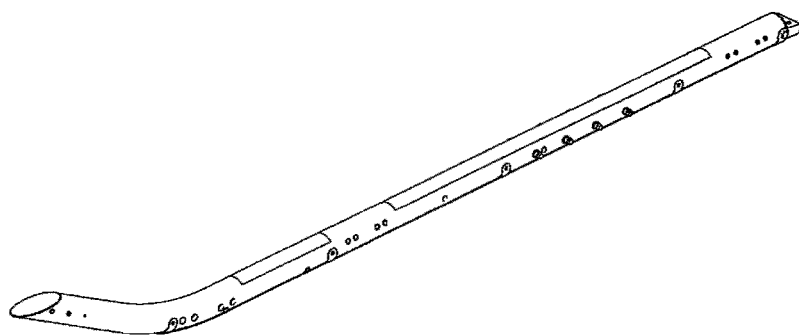
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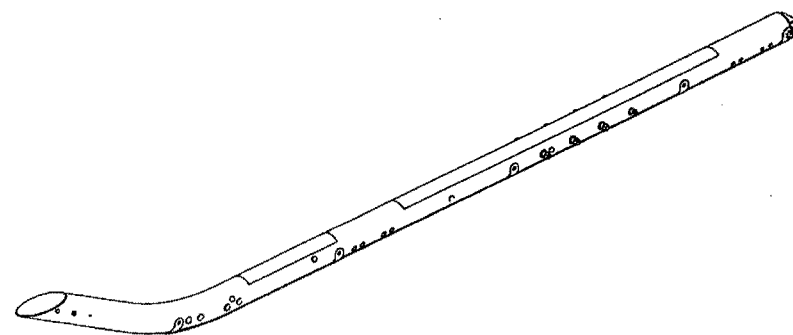
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u/06874



**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

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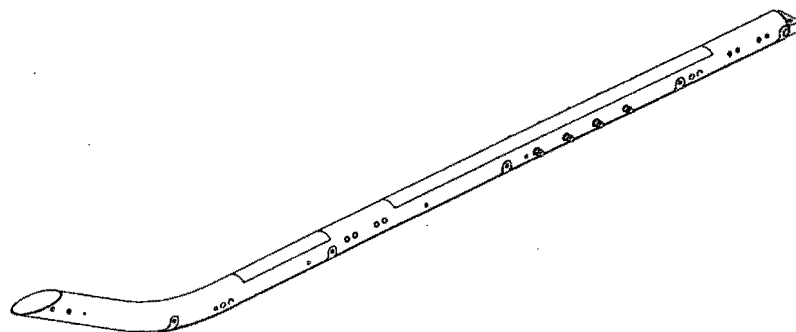
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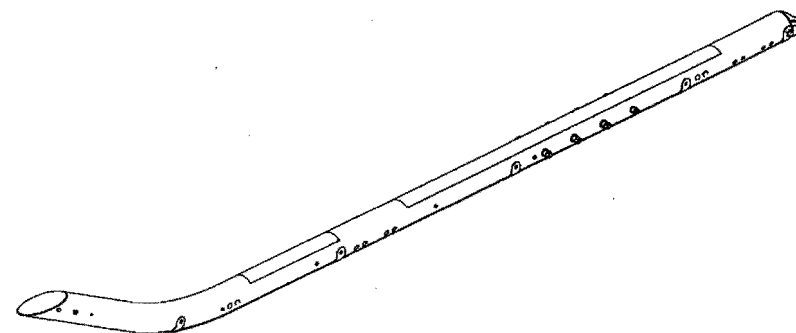
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D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

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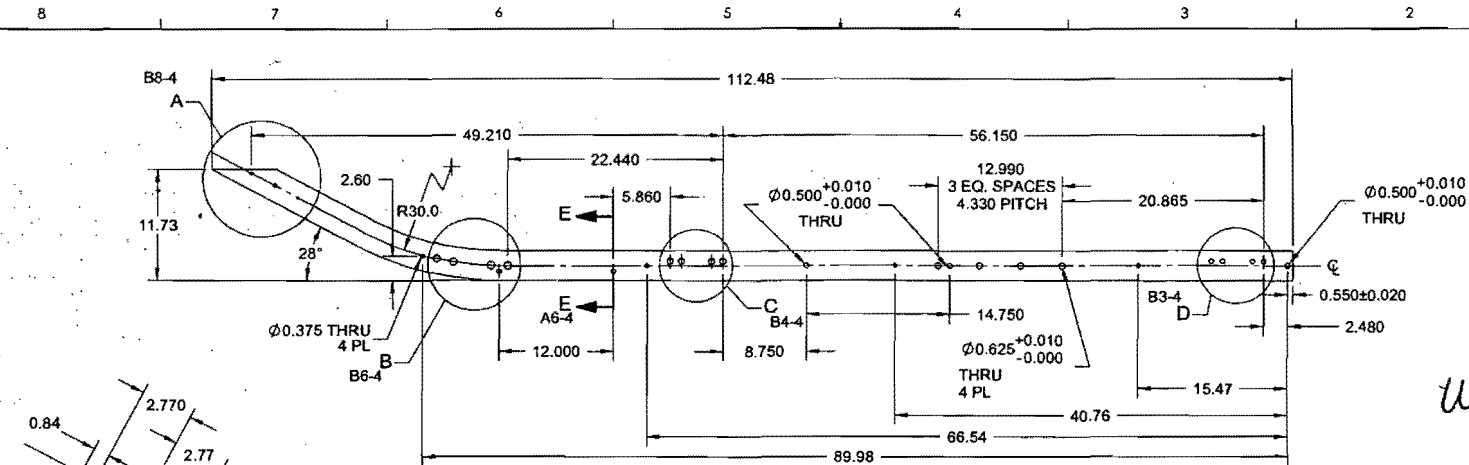
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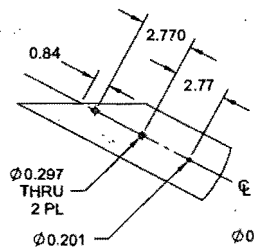
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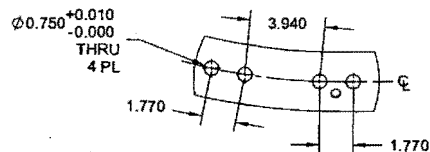
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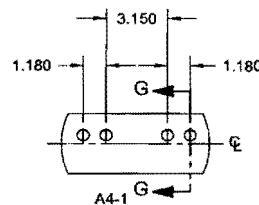
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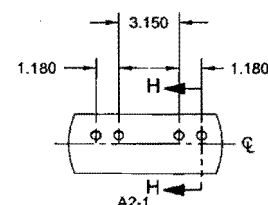
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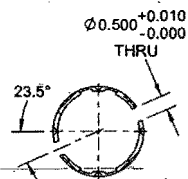
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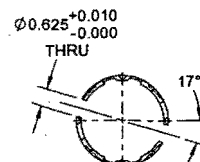
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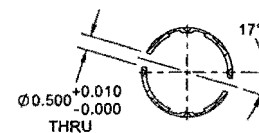
**DETAIL D**  
SCALE 2X



**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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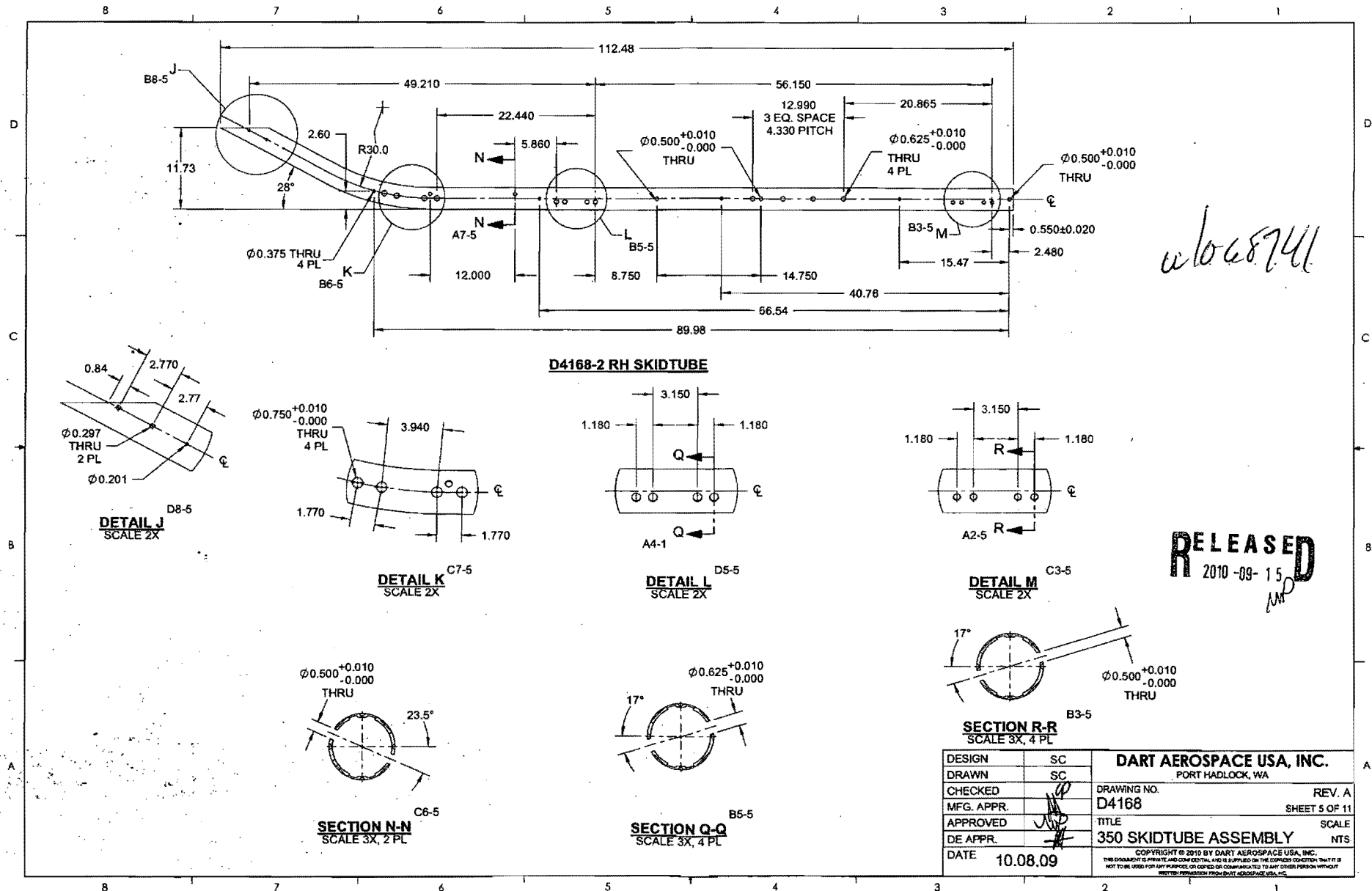
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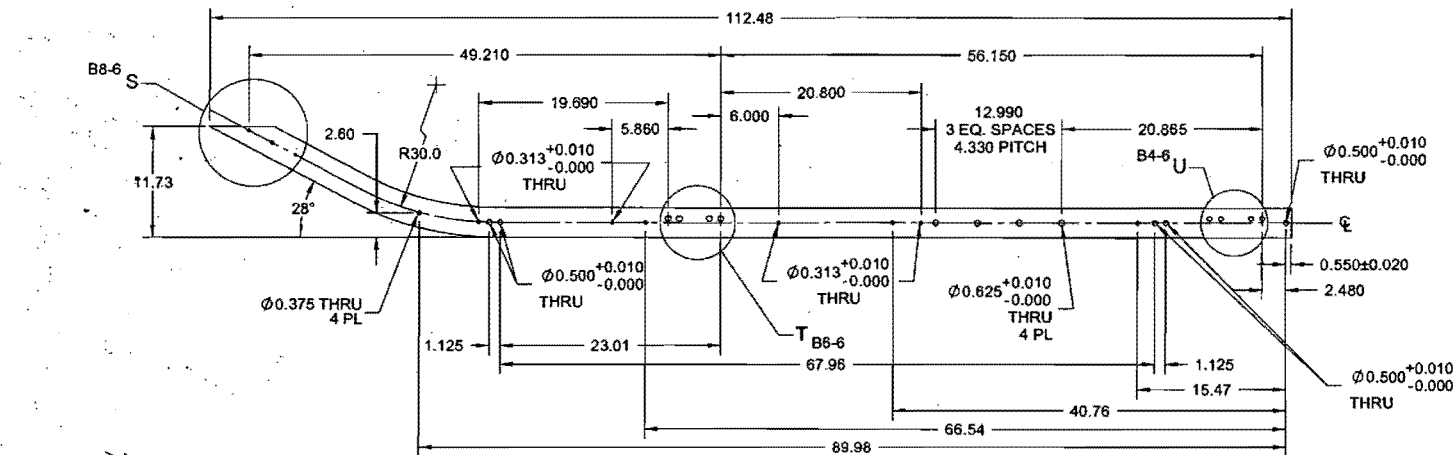
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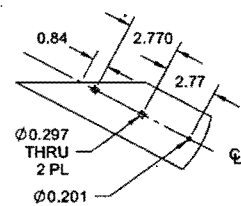
**NOTE:** Date & initial all entries



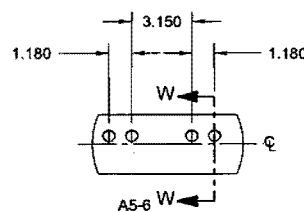
W106874



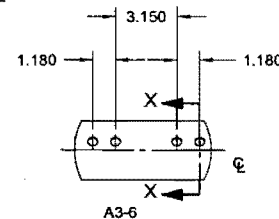
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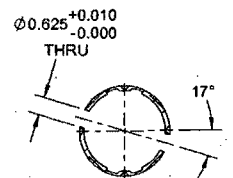
**DETAIL S**  
SCALE 2X



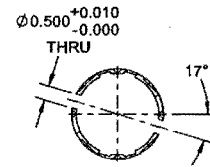
**DETAIL T**  
SCALE 2X



**DETAIL U**  
SCALE 2X



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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D

D

C

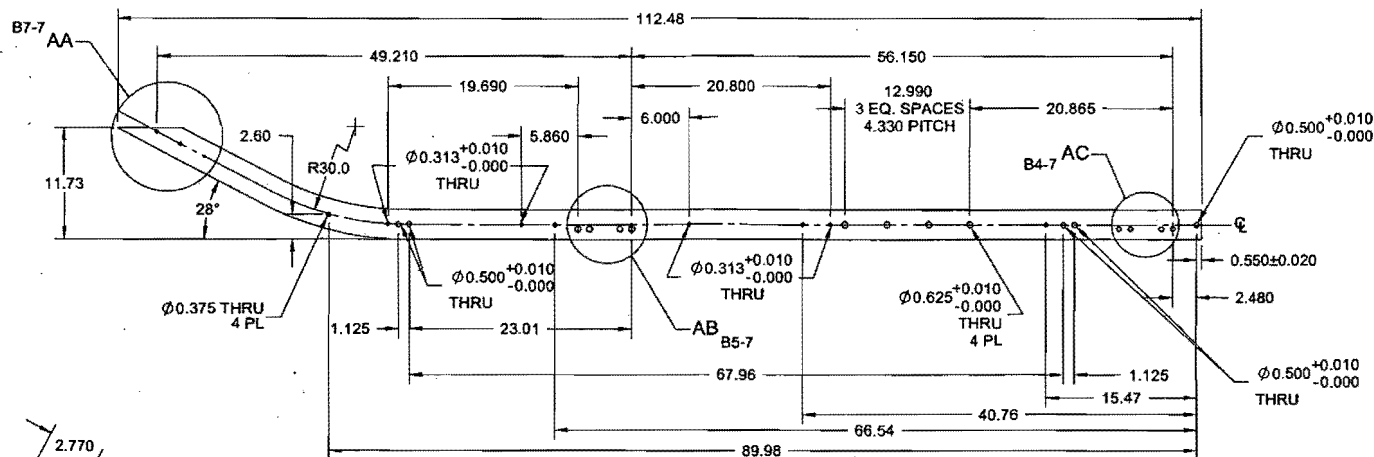
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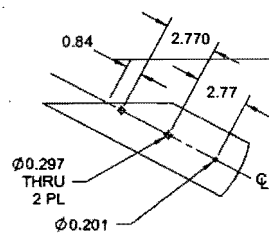
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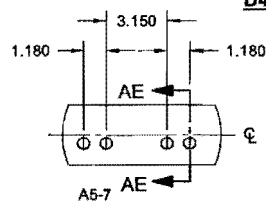
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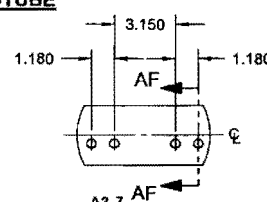
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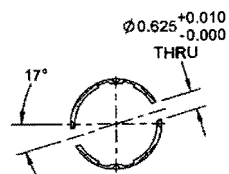
**DETAIL AA**  
D7-7  
SCALE 2X



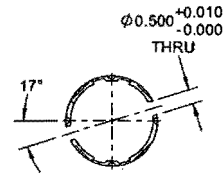
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C4-7  
SCALE 2X



**DETAIL AC**  
D3-7  
SCALE 2X



**SECTION AE-AE**  
B6-7  
SCALE 3X, 4 PL



**SECTION AF-AF**  
B4-7  
SCALE 3X, 4 PL

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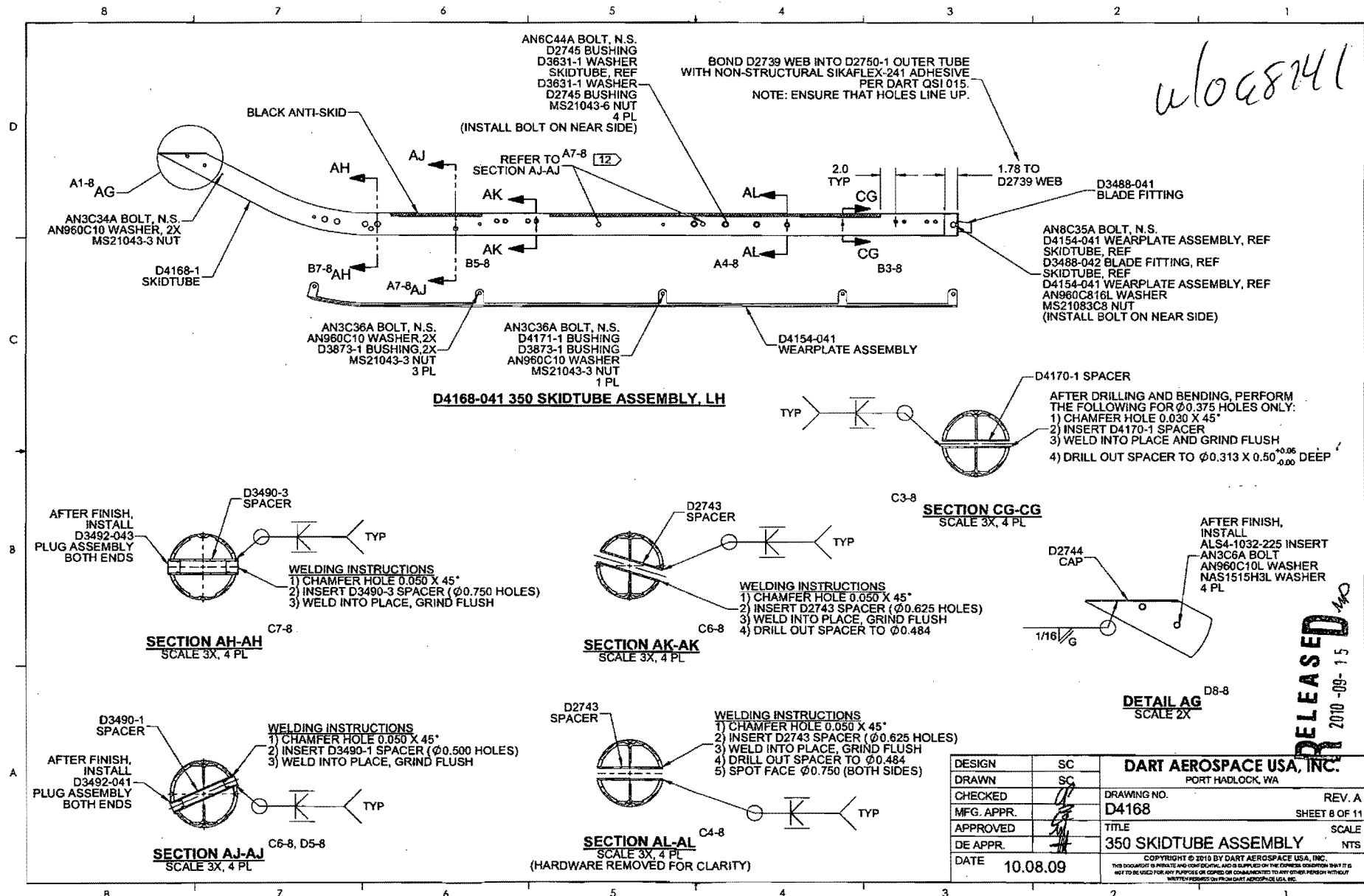
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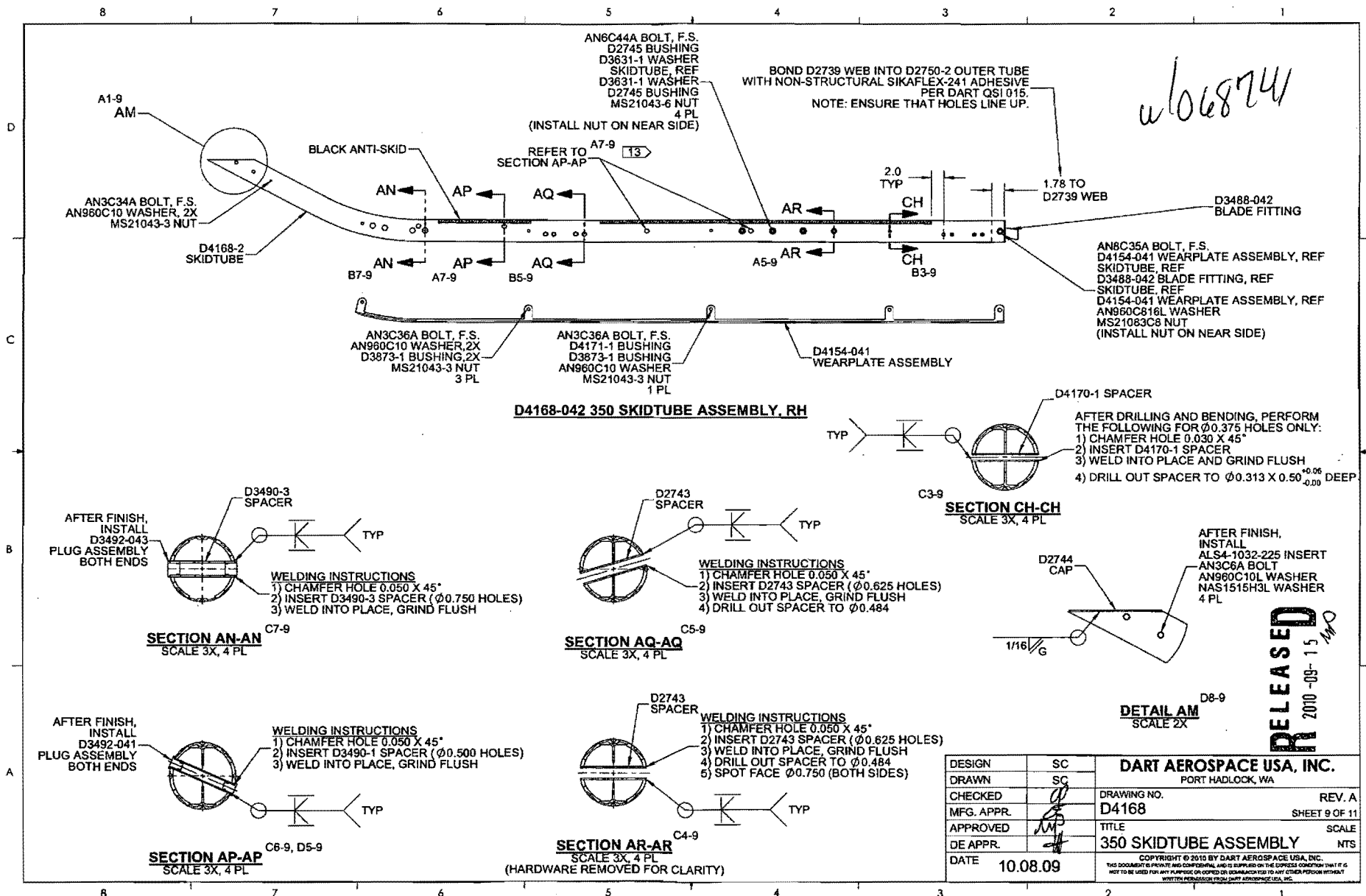
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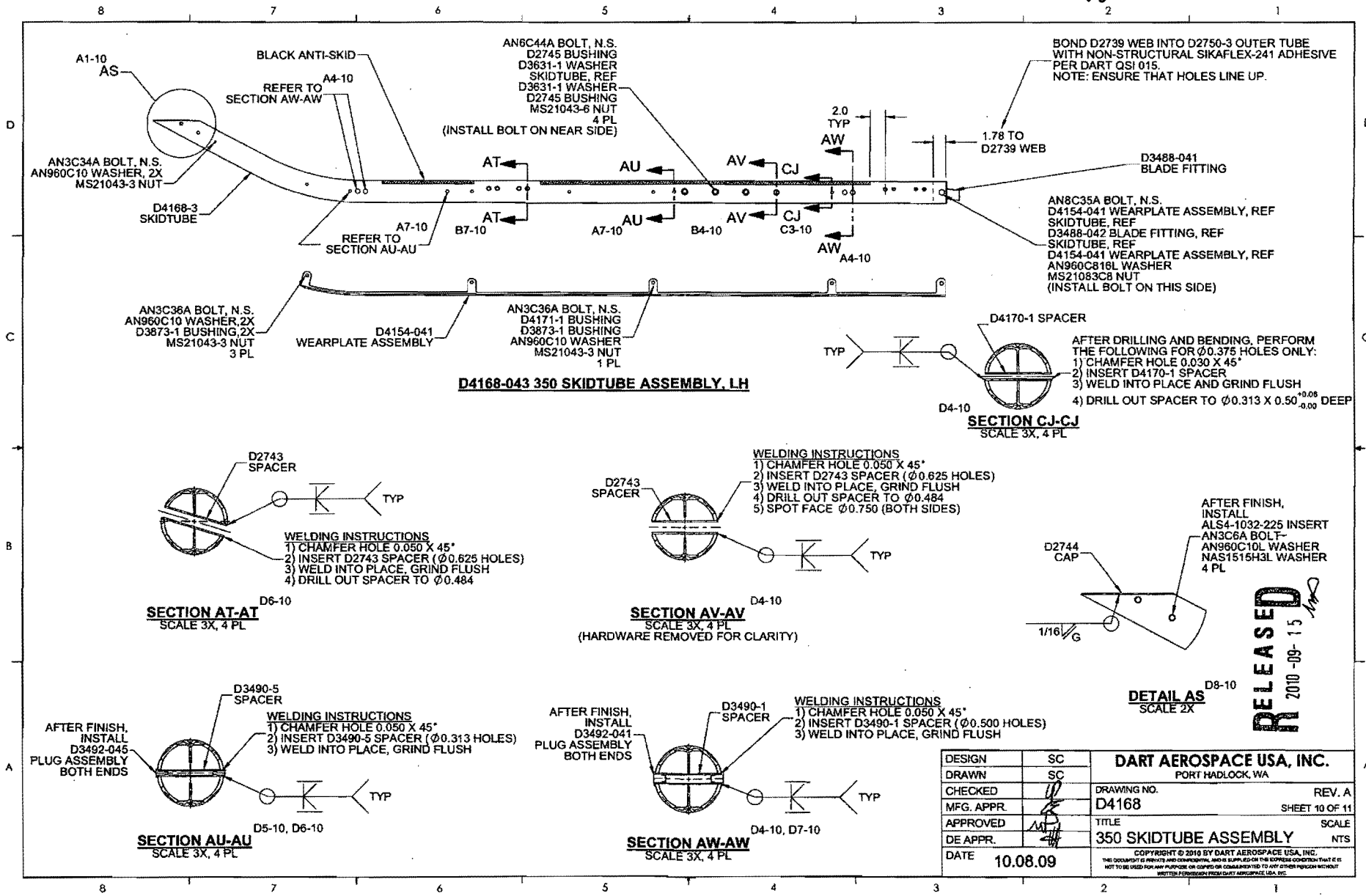
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W668741



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

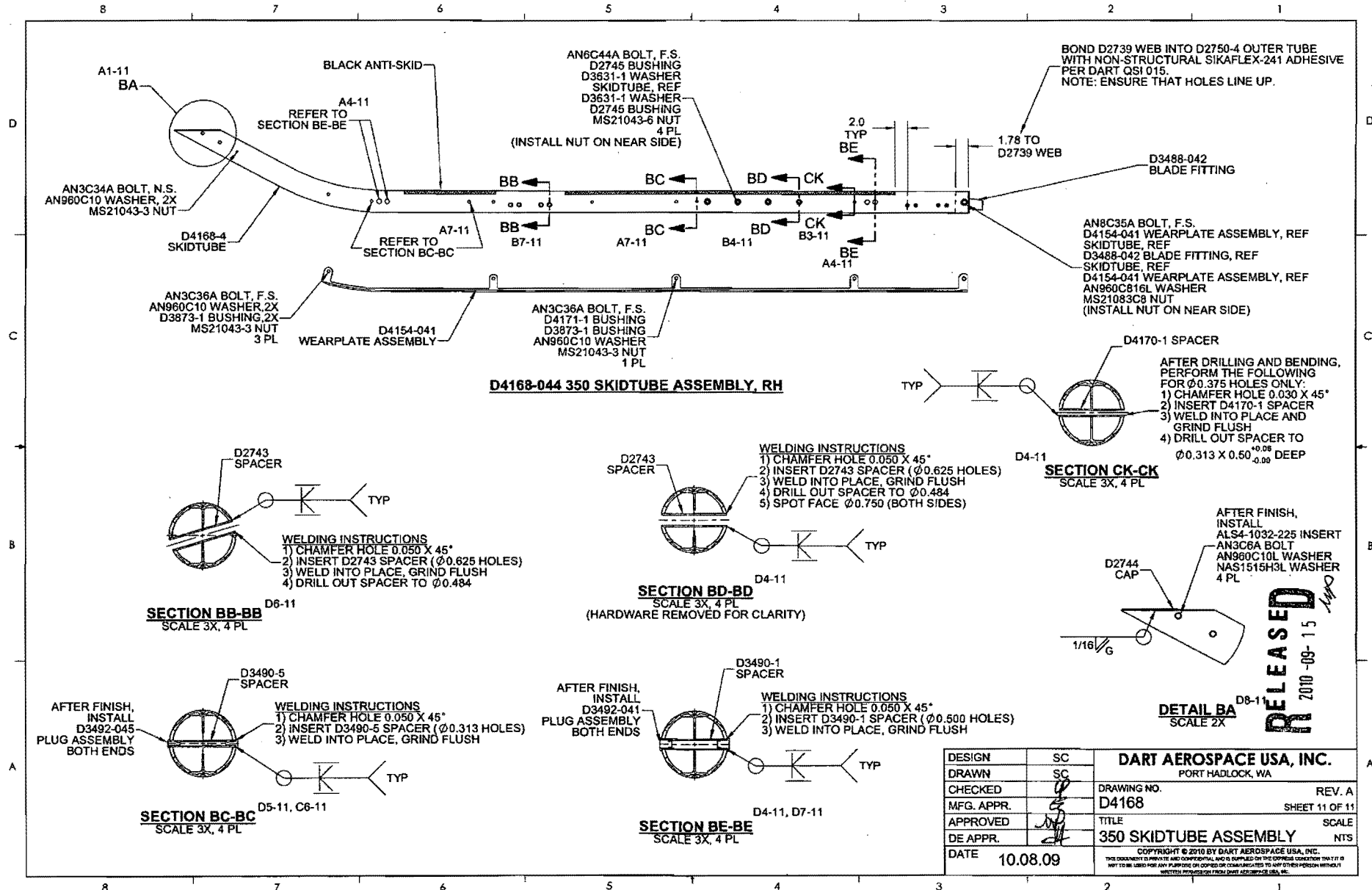
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

WLO 68741



DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 248

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 67178  
Part number: D 350 636 015  
Description: 350  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Lat Dugg Date of Test Coupon 11.04.05  
Welder Barclay Elliott Date of Test Coupon 11.04.05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

